

Work Order ID 83312

Tuesday, April 17, 2012 1:13:54 PM

83312

Page 1

Item ID: D4407-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 4/17/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: *P*

Date: 12-04-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4407	B								

100

0.00

100

Cold Saw

Hyd Mech

Memo

Cut blanks at 66.10"

0.00

amr 12/05/17

20 0

110

0.00

110

HAAS 1.

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB082 & dwg D4407,

FOLIO REV: AA

DWG REV: B

2-Deburr as required

0.00

DA 12/05/20

20 0

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/17/2012 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 4/25/2012 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

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Page 3

Item ID: D4407-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 4/17/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 20.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

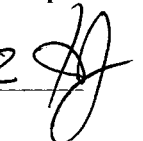
150

QC

Memo

0.00

Quality Control

12/5/22 
MF

12-05-22

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Picklist Print

Tuesday, April 17, 2012 1:13:58 PM

Page 1

Work Order ID: 83312

83312

Parent Item: D4407-1

D4407-1

Parent Item Name: Bar

Start Date: 4/17/2012

Required Date: 4/25/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD
12/02/13 Now on cnc JFS verified by:JLM

IPP revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.250x0.500

Purchased

No

100

f

142.0800

5.508

115.9579

**

M304B0 250x0 500

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT050

142.08

121216

142.08

M121547 X 120'

on 12/05/17

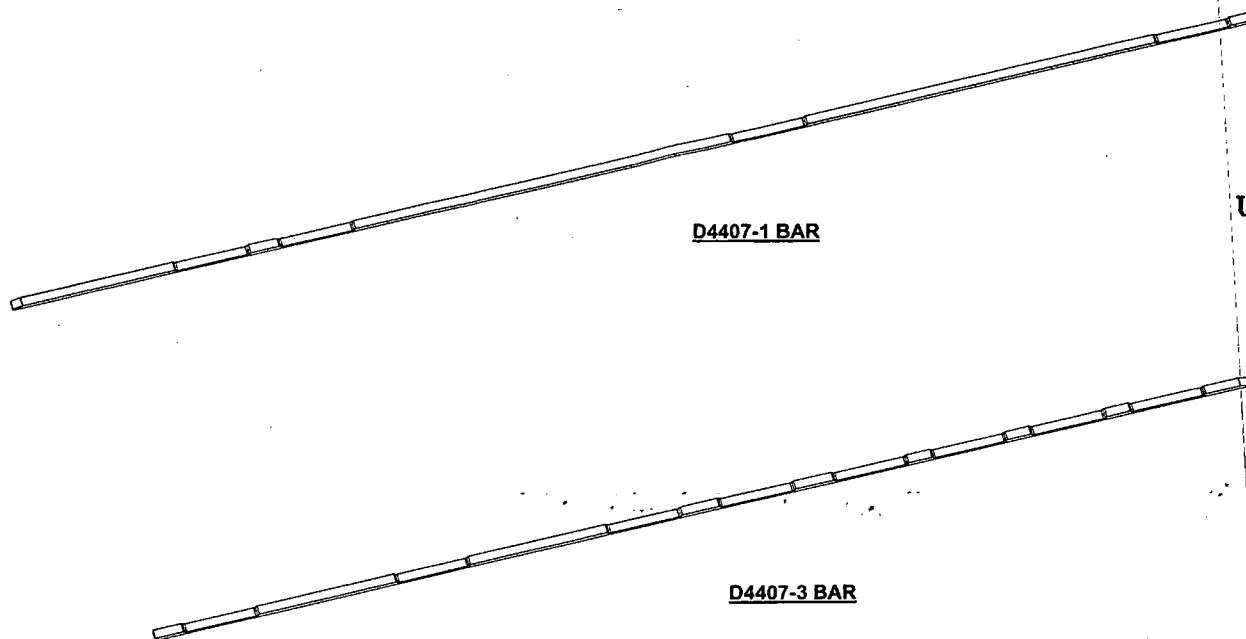
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83312

RD 04-17

RELEASED
2012-02-23
MP

B	REMOVE TOOLING HOLES FOR -1/3; RE-DESIGN D4407-3	RF	12.01.30
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4407	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
DATE	12.01.30	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

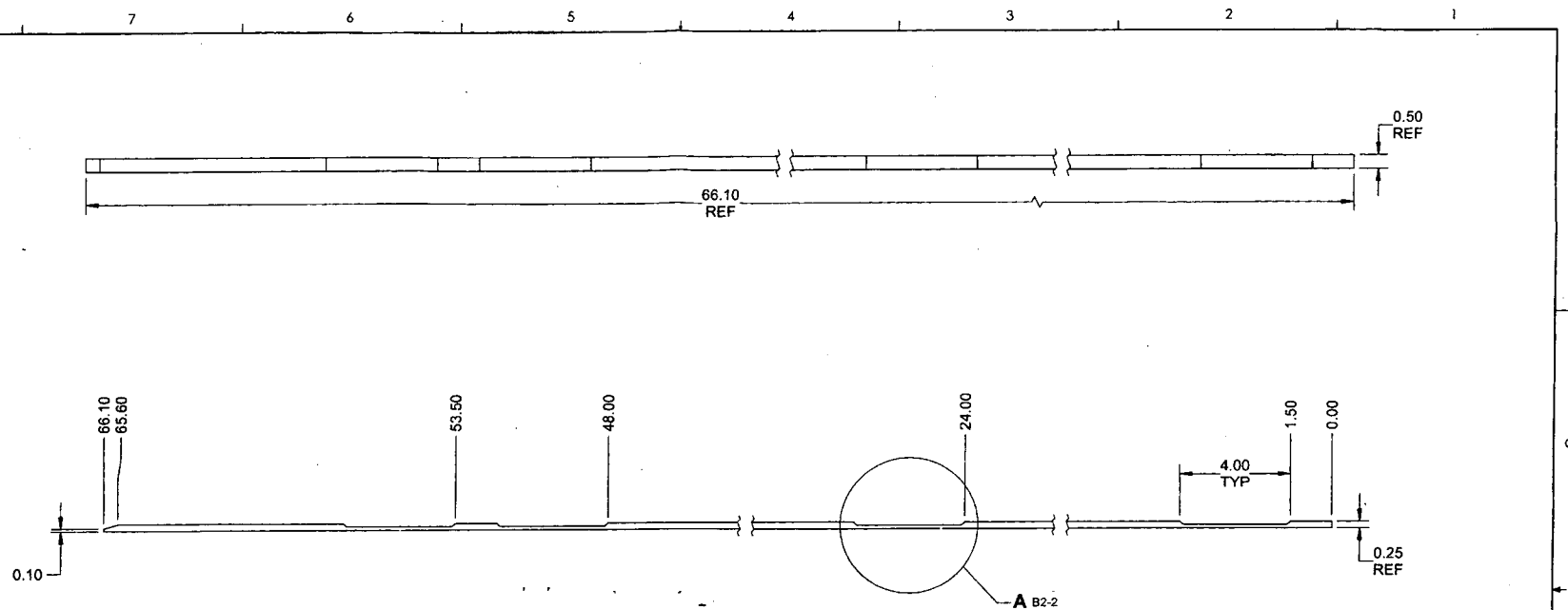
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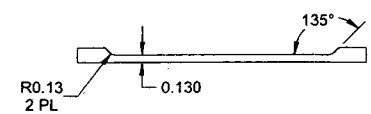
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83312

D4407-1 BAR



DETAIL A C3-2
TYP. SCALE 2X

RELEASE
2012-06-05

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 2.11 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4407	REV. B
MFG. APPR.	RF	SHEET 2 OF 3	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
DATE	12.01.30	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

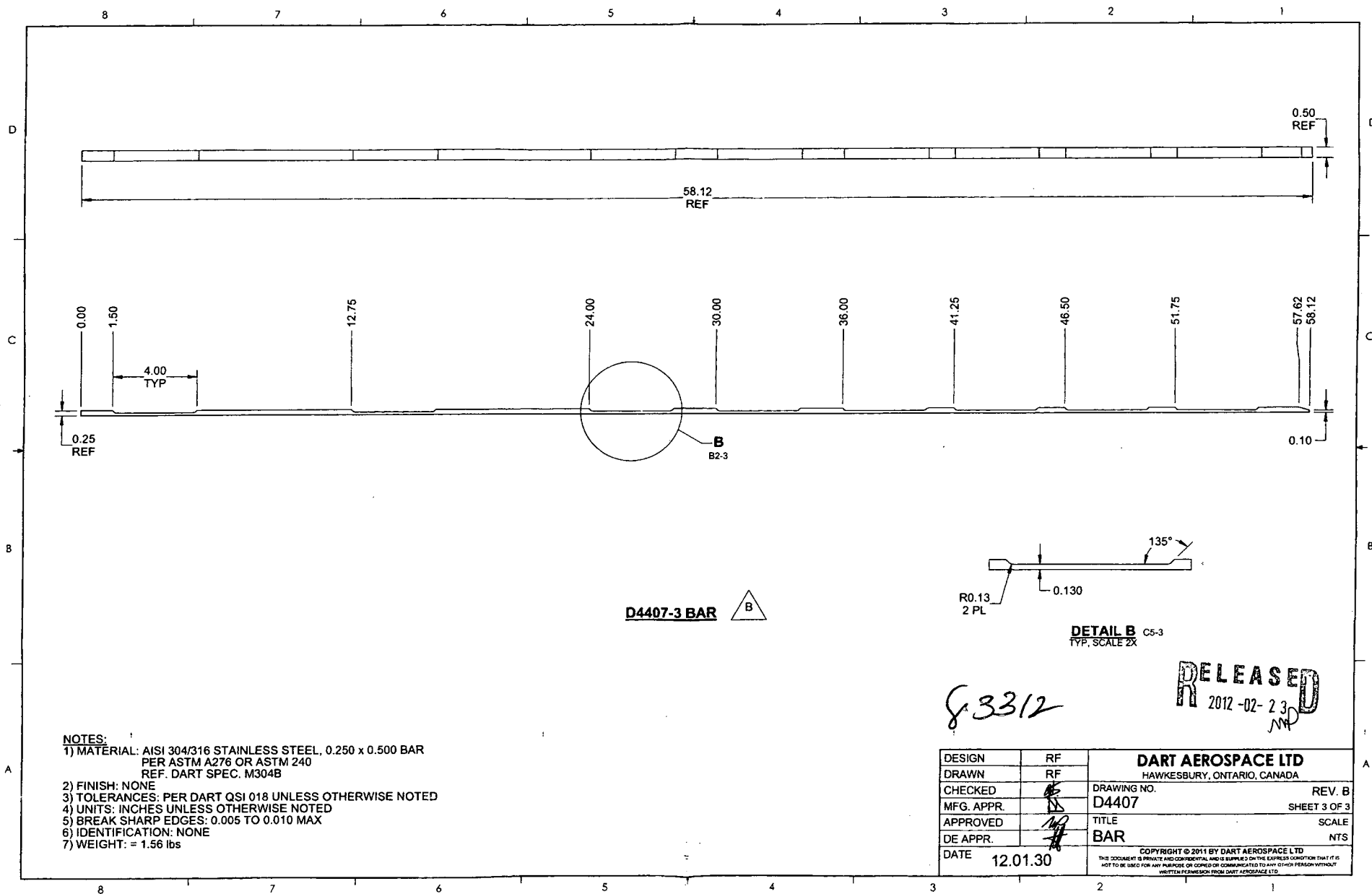
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